

Date: Tuesday, 8/1/2006 11:25:28 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 212 BASKET BASE ASS'Y RH
Job Number	: 28051B		
Estimate Number	: 11543		
P.O. Number	: N/A	Part Number	: D3053042
This Issue	: 8/1/2006	Drawing Number	: D3053 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: A
Previous Run	: 27487B	Material	: N/A
		Due Date	: 8/8/2006
Written By	: <u>JA</u>	Qty:	1 Um: Each
Checked & Approved By	: <u>JA 06.08.01</u>		
Comment	: Est. C 02.08.04 M304EX0.75-16F was M750-16FXS-S/S K J/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
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Comment: Qty.: 45.5000 f(s)/Unit Total: 45.5000 f(s) M101309 → 74.73" Cpl 06.08.15
 304 SQ Tube.75x.75x.065W M101561 → 192" ~~1101~~
 Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: M101359 → ~~58.11.17.09~~

2.0	D31661	Basket Hoop
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Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)
 Basket Hoop
 Qty. 5 D3166-1
 Batch: B27846 B28094

Cpl Cpl-06-08-15

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1
 Cut 5 D2235-3 FROM D3166-1

Drill holes in D3053-3 as per Dwg D3053

Cpl 06-08-15

4.0	D23273	Spacer Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
 Spacer Bushing
 Pick:

Qty Part Number	Description	Batch
2 D2327-3	Bushing	<u>B27051</u>

Cpl 06-08-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 BASKET BASE ASS'Y RH

Job Number: 28051B

Part Number: D3053042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Basket Hinge

Pick:

Qty Part Number Description
2 D2232-3 Hinge plate

Batch

B24527

Ppl 06-08-15

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Mounting Bracket

Pick:

Qty Part Number
2 D2581

Description

Mounting Bracket

Batch

B27587

Ppl 06-08-15

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 50.4000 sf(s)/Unit Total: 50.4000 sf(s)

Expanded Metal Flat Stai

Pick:

Qty Part Number
48sq.ft M304EX0.75-16F

Description

Expanded Metal

Batch

M102001

Ppl 06-09-12

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Remove all markings from material

Drill holes in three D2235-3 ribs as per Dwg D3053 using Jig DT8365

Weld as per Dwg D3053 using Welding Table and corner Jig Deburr as required

****Ensure ribs are positonned for LH****

Ppl 06-08-15

9.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

11/06/09/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: SP Date: 06/09/20

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 8/1/2006 11:25:28 AM
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Job Number: 28051B

Part Number: D3053042

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Take Traveller D205-541-043 to KP

FL 06 09 18D

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

FL 06 09 18D

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

am 06-09-19

8

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G.A.

06/09/19 ①

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/20 ①

Job Completion



W 06.09.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

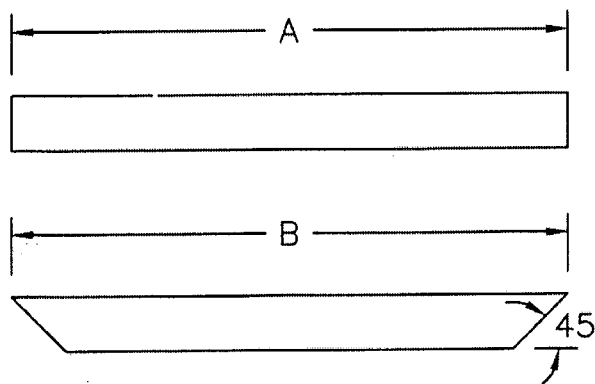


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3053	REV. A SHEET 1 OF 3
DATE 01.11.01		TITLE BASKET BASE ASSEMBLY (212)	SCALE NTS
A	01.11.01	NEW ISSUE	

RELEASED
01.12.20 #

PARTS LIST FOR D3053-041/D3053-042 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3053-1	2	—	96.00	RIB
D3053-3	2	—	25.50	RIB
D3053-5	6	23.73	—	RIB
D3053-7	3	25.31	—	RIB
D3053-9	3	19.48	—	RIB
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRKT
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-3	5	N/A	N/A	RIB



NOTES:

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
- 3) MESH MATERIAL: 3/4-16F EXPANDED SS
- 4) WELD PER DART QSI 004
- 5) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER

NO. 28051B

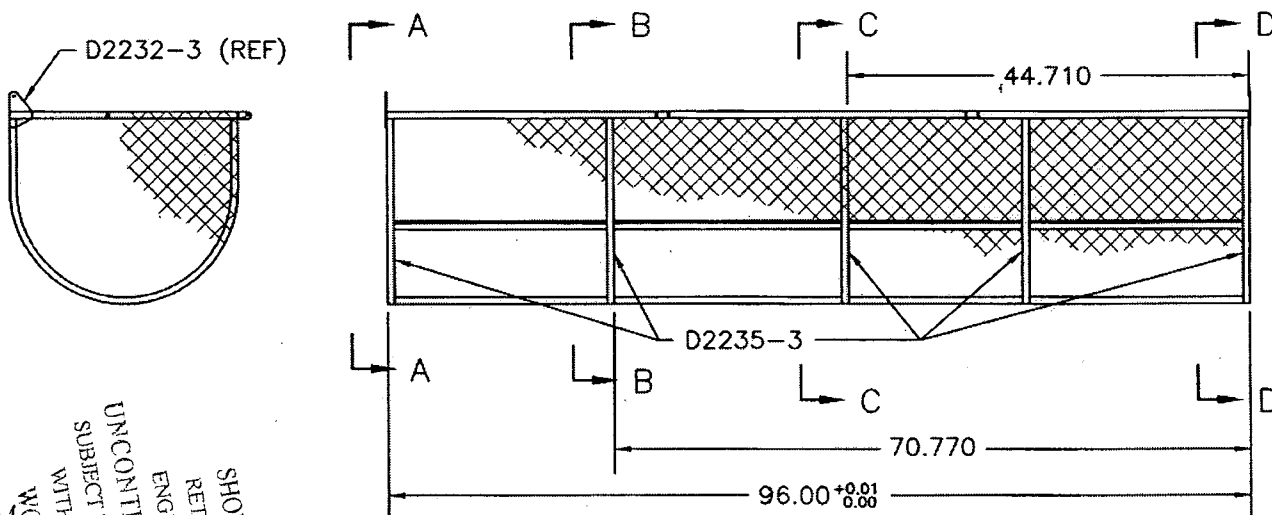
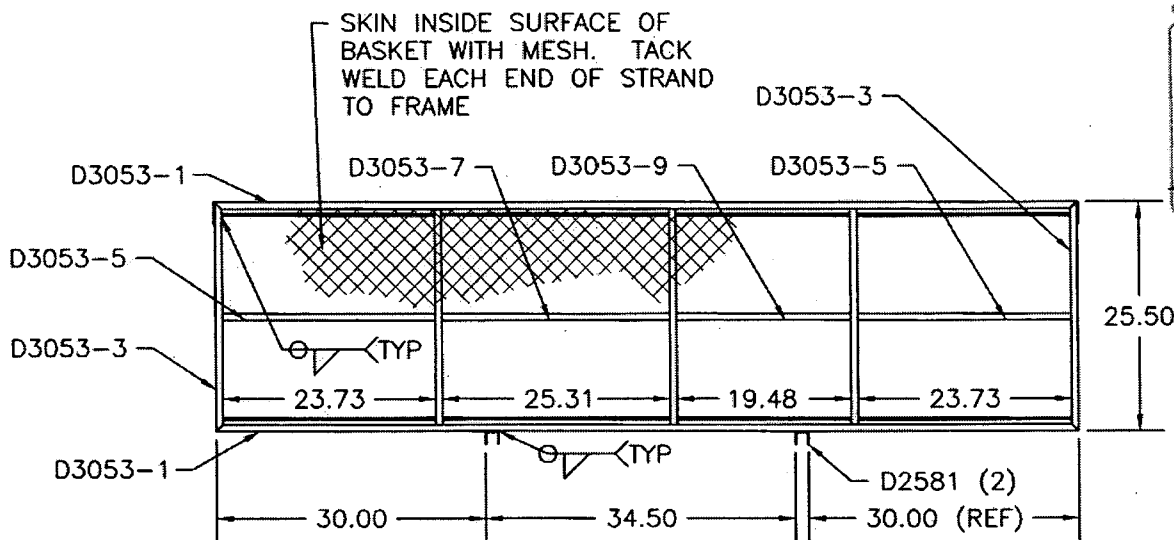
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	01.11.01	TITLE	BASKET BASE ASSEMBLY (212)	REV. A
		DRAWING NO.	D3053	SHEET 2 OF 3
				SCALE

RELEASED
d 12.20 47

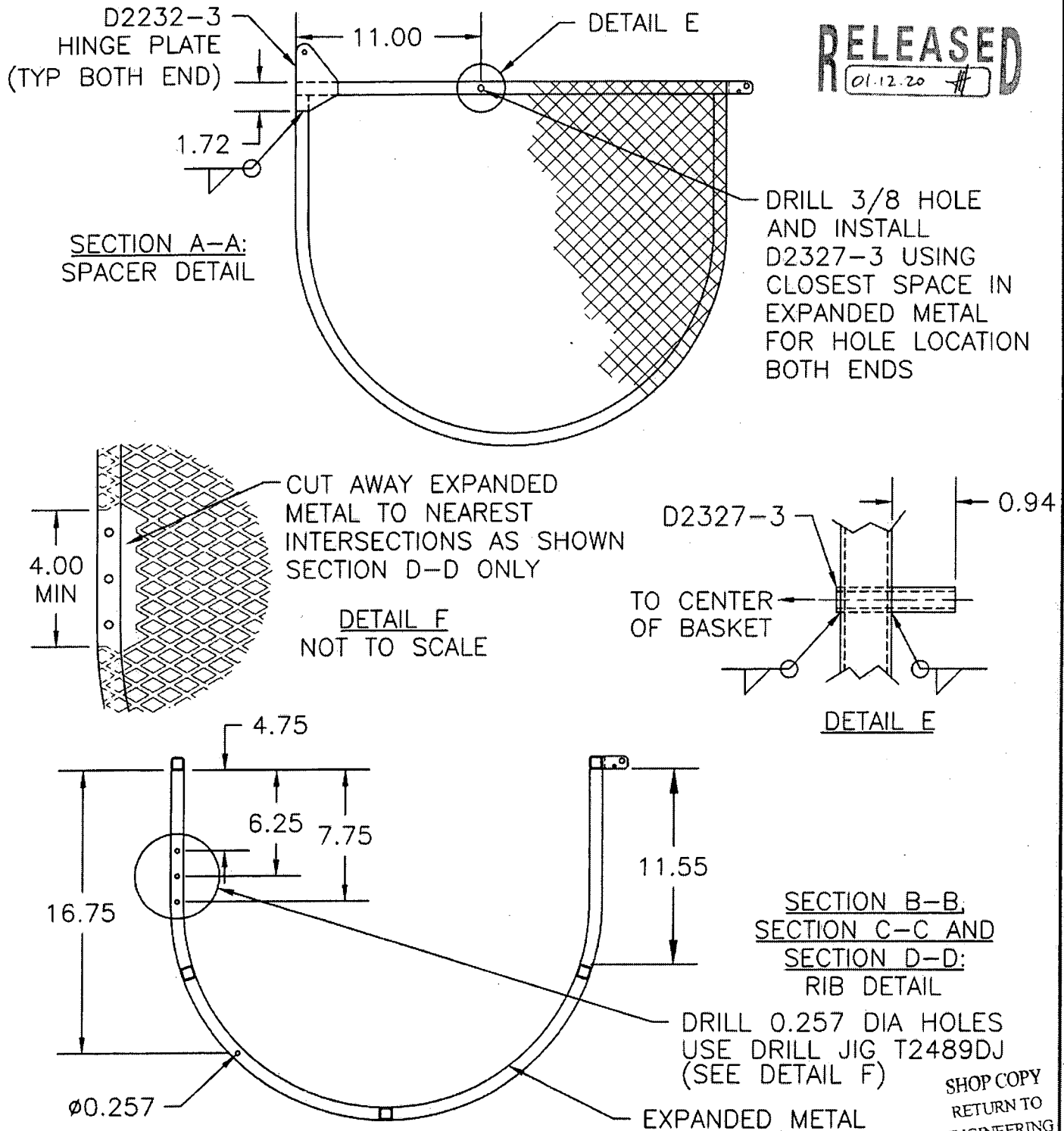


D3053-042 BASKET BASE ASSEMBLY SHOWN
(D3053-041 BASKET BASE ASSEMBLY OPPOSITE)

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DART

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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3053	REV. A SHEET 3 OF 3
DATE 01.11.01	TITLE BASKET BASE ASSEMBLY (212)		SCALE 1:8



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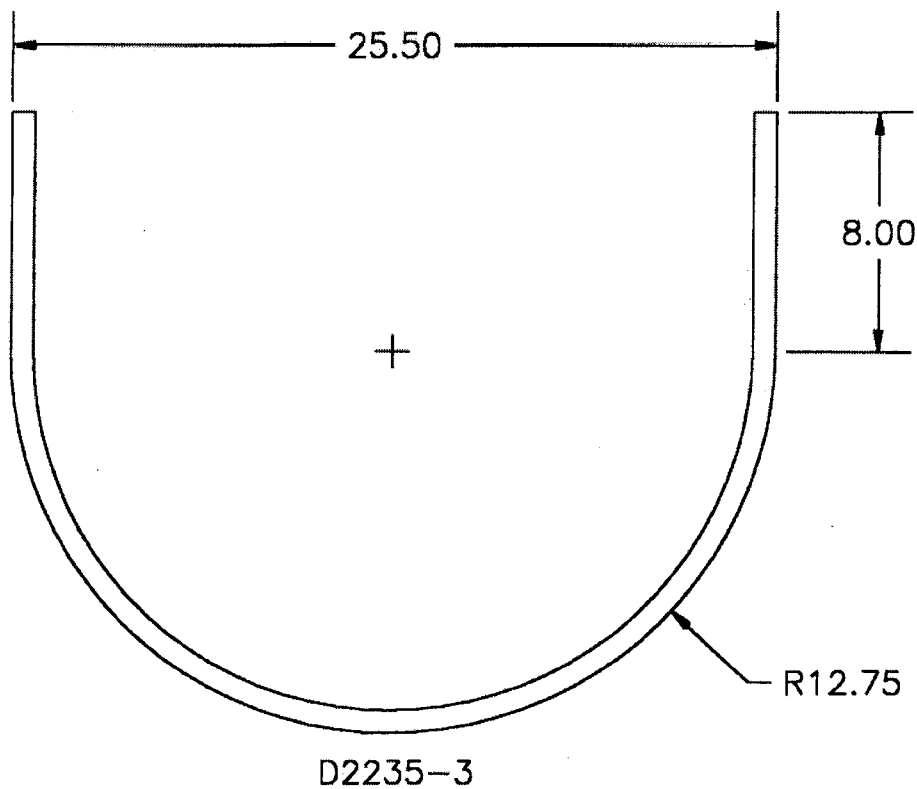
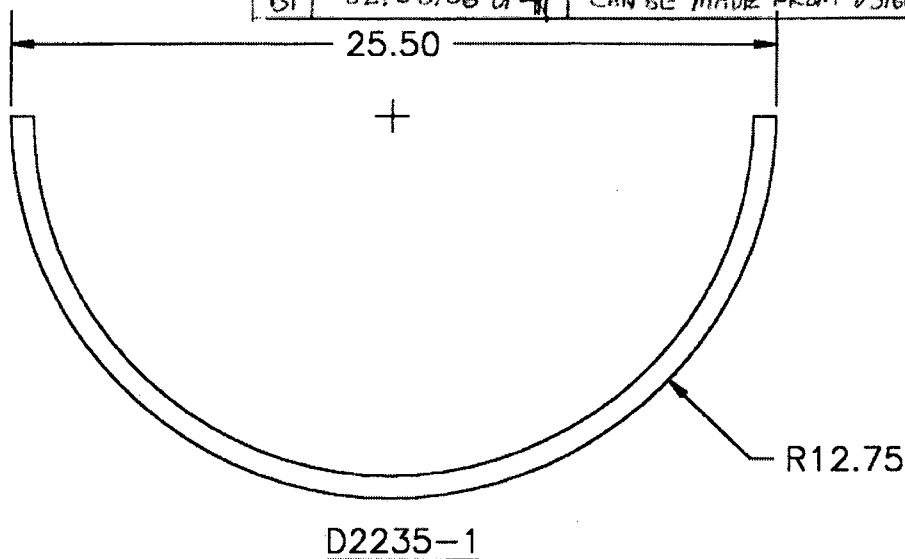
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B WILLIAMS	B WILLIAMS	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
<i>BW</i>	<i>BW</i>	D2235	SHEET 1 OF 1
DATE	TITLE		SCALE
94:12:16	BASKET RIBS		
BI	02.08.06 <i>UP</i>	CAN BE MADE FROM D3166-1	

RELEASED
R 960507



CAN BE MADE FROM D3166-1 \triangle BI
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR

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